

Work Order ID 68217

Friday, April 08, 2011 3:00:21 PM



Page 1

Item ID: D3955-23

Accept



Setup Start



Revision ID:

Stop



Item Name: Template

Start Date: 4/8/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *H* Date: 4-04-11 Tooling: Date:

QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3955	A

100 0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3955

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

 B11-4-11

 G

110 0.00



QC

Memo

0.00

Quality Control

 B11-4-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Subaru

ECO

Quality Control

130

Identify as per dwg & Stock Location: 98

0.00



Packaging

Memo

0.00

11/4/11

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

11/4/12

Quality Control

6660412

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Friday, April 08, 2011 3:00:29 PM

Page 1

Work Order ID: 68217



Parent Item: D3955-23



Parent Item Name: Template

Start Date: 4/8/2011

Required Date: 4/12/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.040

Purchased

No

sf

16.0000

1.668211



11-4-11

6061-T6 .040 Sheet

Location

Loc Qty

Loc Code

MAT021

16

113004

16

113004

(4)

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DART AEROSPACE LTD		Work Order: 68217
Description: Template		Part Number: D3955-23
Inspection Dwg: D3955	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article** ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.101	✓		V B02	
Ø0.129	+0.005/-0.001	.132	✓		V	
0.750	+/-0.010	.747	✓		V	
1.000	+/-0.010	1.001	✓		V	
1.250	+/-0.010	1.247	✓		V	
1.375	+/-0.010	1.374	✓		V	
2.563	+/-0.010	2.565	✓		V	
0.800	+/-0.010	.806	✓		V	
1.500	+/-0.010	1.497	✓		V	
2.250	+/-0.010	2.252	✓		V	
2.750	+/-0.010	2.751	✓		V	
3.250	+/-0.010	3.253	✓		V	
5.000	+/-0.010	5.003	✓		V	
6.500	+/-0.010	6.497	✓		V	
7.500	+/-0.010	7.500	✓		V	
8.000	+/-0.010	8.003	✓		V	
8.500	+/-0.010	8.501	✓		Pro W 502	
9.375	+/-0.010	9.375	✓		P	
9.625	+/-0.010	9.623	✓		P	
10.600	+/-0.010	10.606	✓		P	
11.13	+/-0.030	11.125	✓		P	
0.040	+/-0.010	.037	✓		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 11-4-11	Date: 11/04/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	

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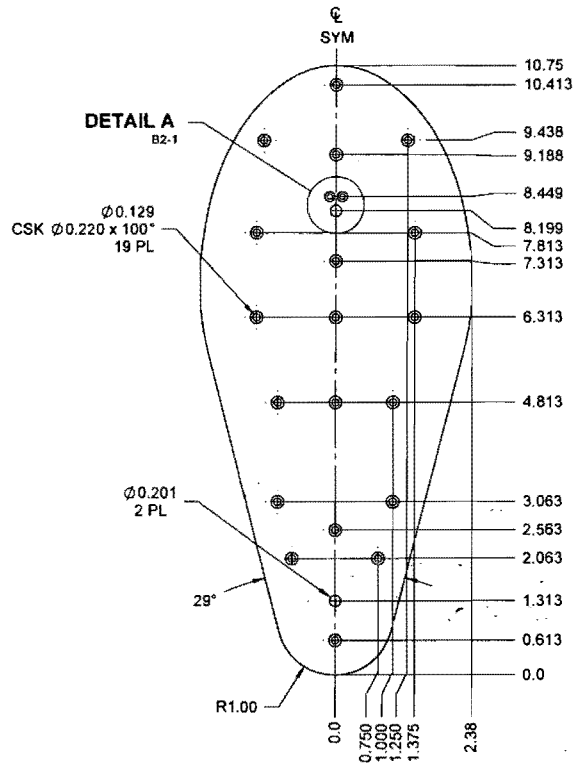
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68217

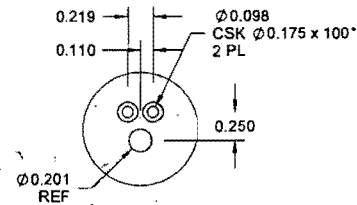
ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3955-041	DOUBLER ASSY
2	1	D3955-1	DOUBLER
3	1	MS21086L3	NUT PLATE
4	2	MS20427M3-3	RIVET



INSTALL
MS21086L3 NUT PLATE
MS20427M3-3 RIVET, 2 PL

CSK SIDE

D3955-1
DOUBLER



DETAIL A D7-1
SCALE 2X

D3955-1 DOUBLER

D3955-1 NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.063 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N "D3955-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.25 lbs

D3955-041 DOUBLER ASSEMBLY

RELEASED
09/07/21

A	NEW ISSUE	RF	09.07.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.07.21		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. **D3955**
REV. A
SHEET 1 OF 5
TITLE **SKIDTUBE TUNING KIT**
SCALE NTS

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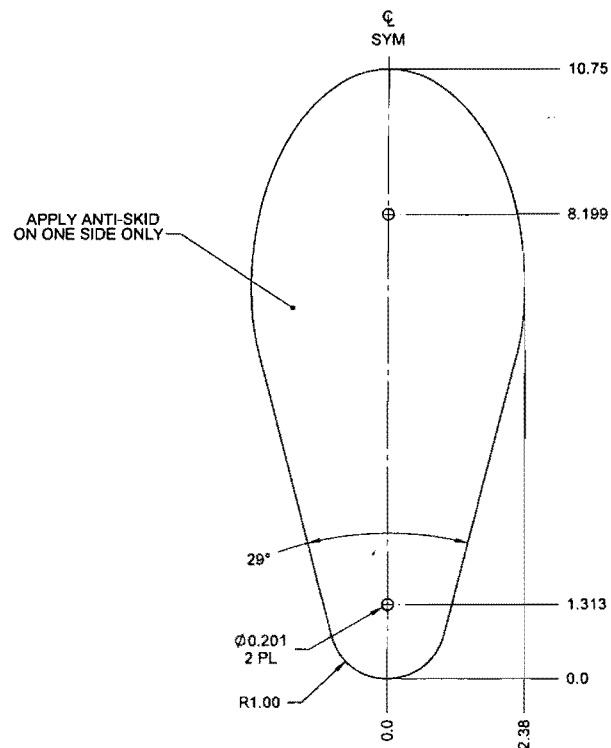
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
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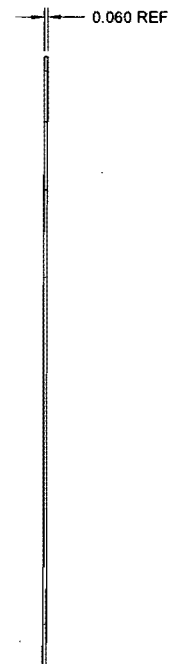
NOTE: Date & initial all entries



D3955-3 COVER PLATE

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.060 (16 GA) THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.64 lbs



w/c 68217

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09/07/21

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3955	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE TUNING KIT	NTS
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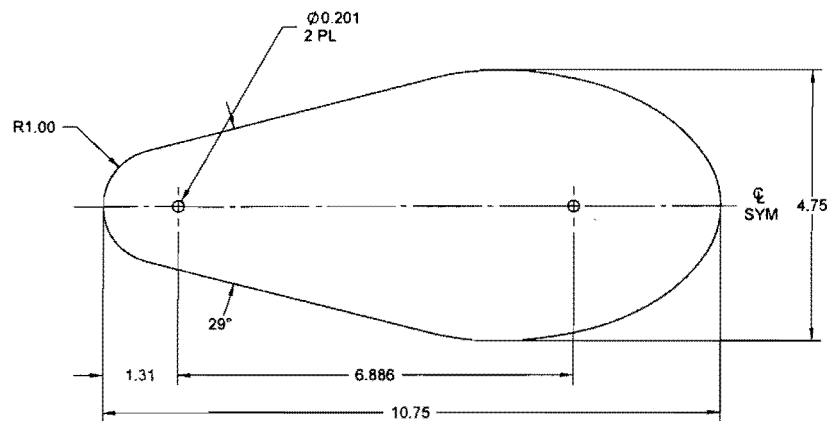
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NOTE: Date & initial all entries



D3955-X PLATE

w/068217

General Table			
P/N	T (in)	T (GA)	WEIGHT (lbs)
D3955-5	0.060	16	0.64
D3955-7	0.120	11	1.28

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, T (GA) THICK (REF. DART SPEC. M304S'T'GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: SEE TABLE

RELEASED
01/07/22 MJD

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3955	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SKIDTUBE TUNING KIT	NTS
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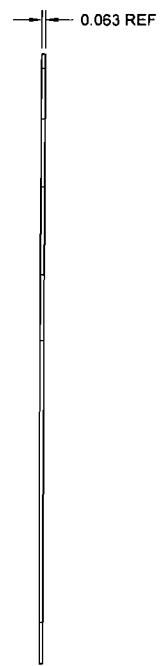
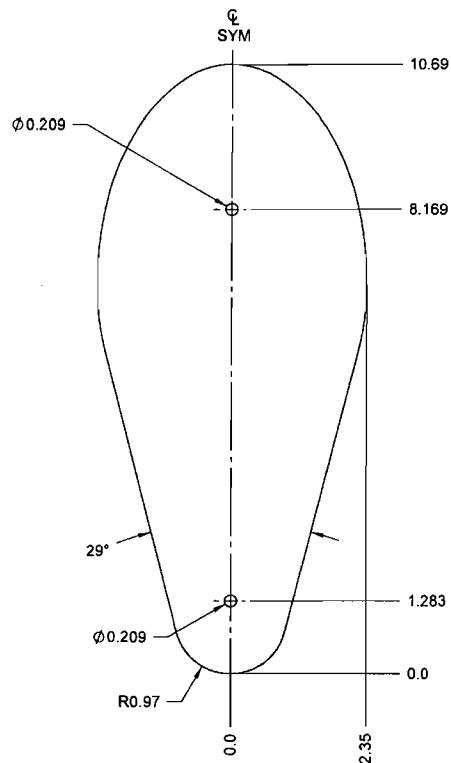
8 7 6 5 4 3 2 1

D

C

B

A



D

C

B

A

W/68217

RELEASED
27/07/22 MTH

D3955-21 GASKET

- D3955-21 NOTES:**
 1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER (REF. DART SPEC. M-NEO60-S.063)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-21" USING YELLOW PAINT MARKER
 7) WEIGHT: 0.08 lbs

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MFG. APPR.		D3955	SHEET 4 OF 5
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8 7 6 5 4 3 2 1

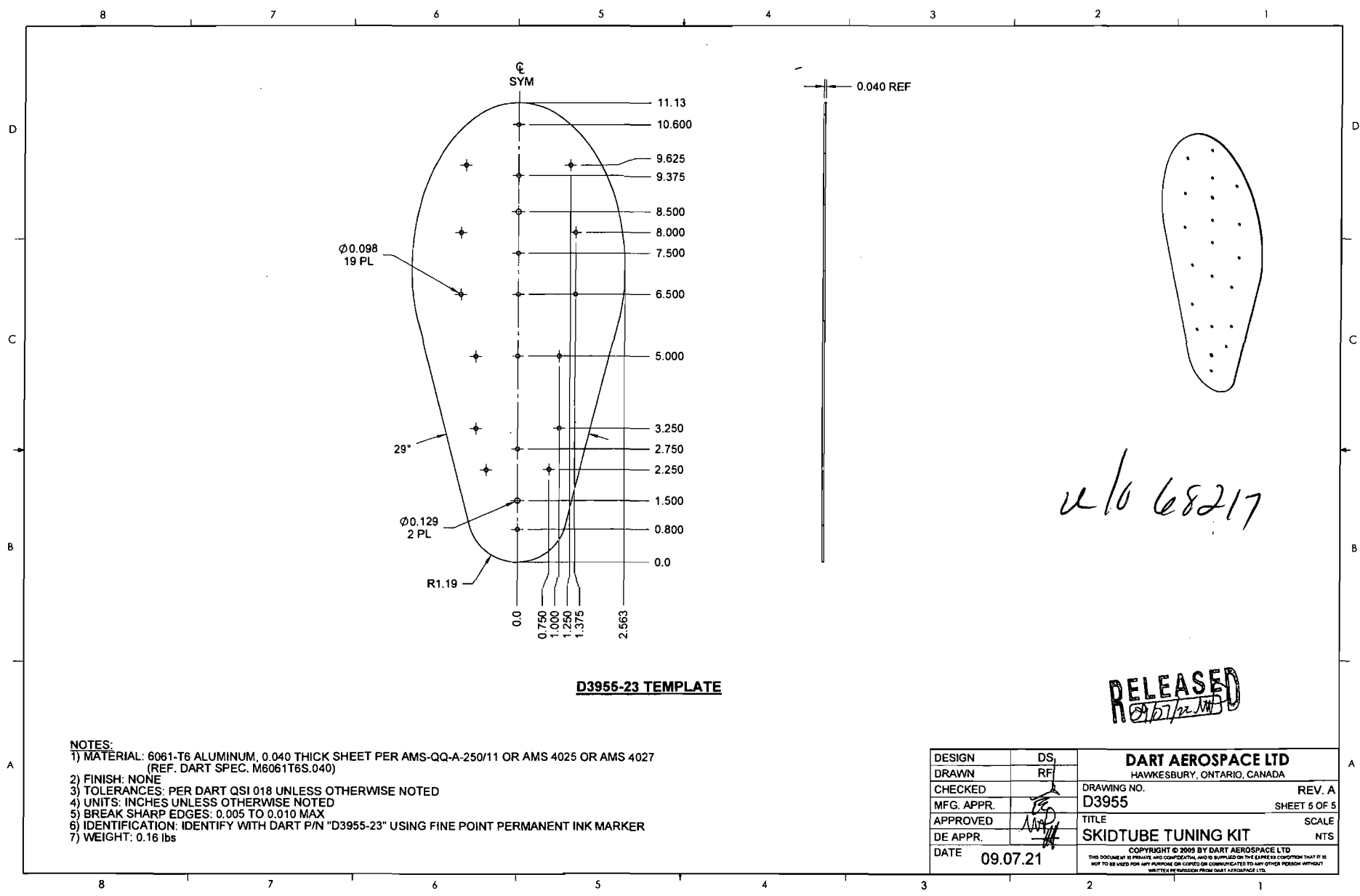
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u10 68217

RELEASED
01/07/22 MB

- NOTES:**
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 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-23" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.16 lbs

DESIGN	DS	DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3955	SHEET 5 OF 5
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